

Ship 4/13/10

Work Order ID 57587



Item ID: D3608-3

Accept



Setup Start



Revision ID:

Item Name: Upper Doubler

Stop



Start Date: 4/09/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/13/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3608

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3608
Dwg Rev: B
Prog Rev: B
2-Deburr if necessary

HB 10-4-12

(6)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

HB 10-4-12

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

S 4/6/12

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 57587

April 9, 2010 11:22:35 AM



Page 2

Item ID: D3608-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Upper Doubler

Start Date: 4/09/10

Start Qty: 4.00



Cust Item ID:

Required Date: 4/13/10

Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: 175

0.00



Packaging

Memo

0.00

Packaging

10/14/22 (6)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/23
MF 10-4-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April 9, 2010 11:22:34 AM

Page 1

Work Order ID: 57587



Parent Item: D3608-3



Parent Item Name: Upper Doubler

Start Date: 4/09/10

Required Date: 4/13/10

Comments:

IPP Rev:A New Issue 07-03-26 JLM
IPP Rev:B 08-10-15 preliminary issue DD verified by:EC
IPP Rev:C 08-12-11 rev.A as per dwg DD verified by:EC IPP
Rev:D 10.02.16 rev.B as per dwg DD verified by:EC

Start Qty: 4.00 2

Required Qty: 4.00

M304S20GA

Purchased

No

100

sf

79.0000

3.1124



304/316 .040 Sheet

5

HB 10-4-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT20

79

112885

15

113062

64

112885

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 52587
Description: Upper Doubler		Part Number: D3608-3
Inspection Dwg: D3608	Rev: B	Page 1 of 1

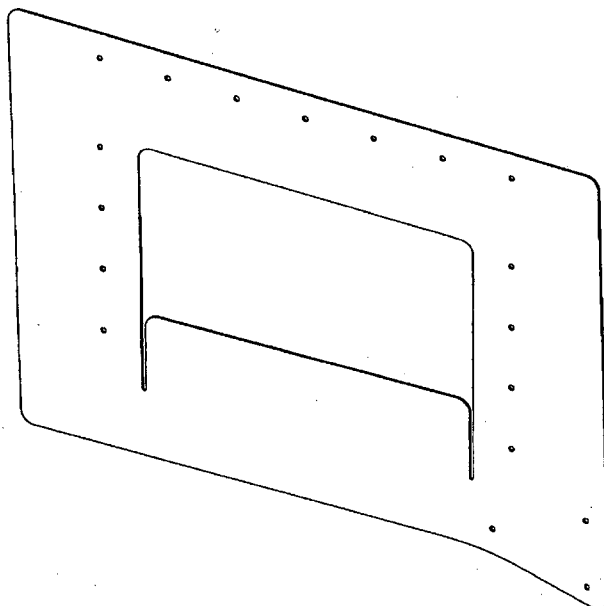
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

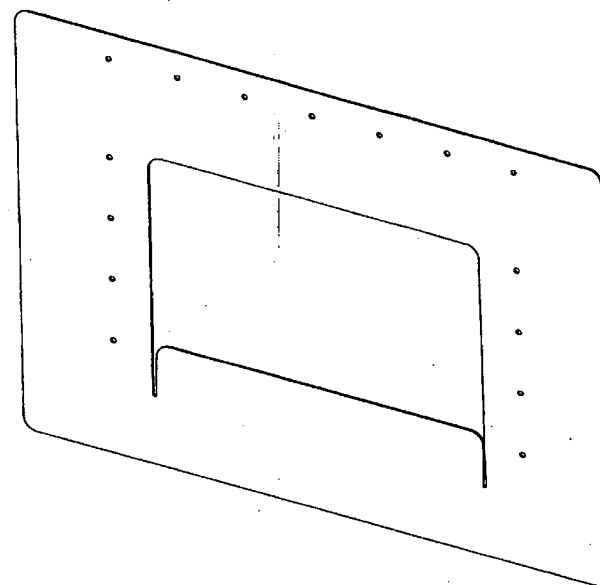
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.004/-0.001	.101	✓			
1.820	+/-0.010	1.816	✓			
0.500	+/-0.010	.498	✓			
1.325	+/-0.010	1.328	✓			
7.950	+/-0.010	7.951	✓			
11.50	+/-0.030	11.502	✓			
2.50	+/-0.030	2.528	✓			
3.750	+/-0.010	3.752	✓			
1.250	+/-0.010	1.251	✓			
8.50	+/-0.030	8.497	✓			
0.75	+/-0.030	.753	✓			
2.46	+/-0.030	2.463	✓			
6.45	+/-0.030	6.444	✓			
6.51	+/-0.030	6.509	✓			
11.63	+/-0.030	11.625	✓			
2.53	+/-0.030	2.531	✓			
1.41	+/-0.030	1.415	✓			
3.750	+/-0.010	3.753	✓			
1.250	+/-0.010	1.251	✓			
8.56	+/-0.030	8.560	✓			
2.53	+/-0.030	2.533	✓			
0.040	+/-0.010	.037	✓			

Measured by: WB	Audited by: S	Prototype Approval:	N/A
Date: 10-4-12	Date: 10/6/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	
B	10.02.18	Dimensions updated per Dwg Rev B	KJ	



D3608-1 LOWER DOUBLER



D3608-3 UPPER DOUBLER

RELEASED
2010-02-10

ul 2 57587

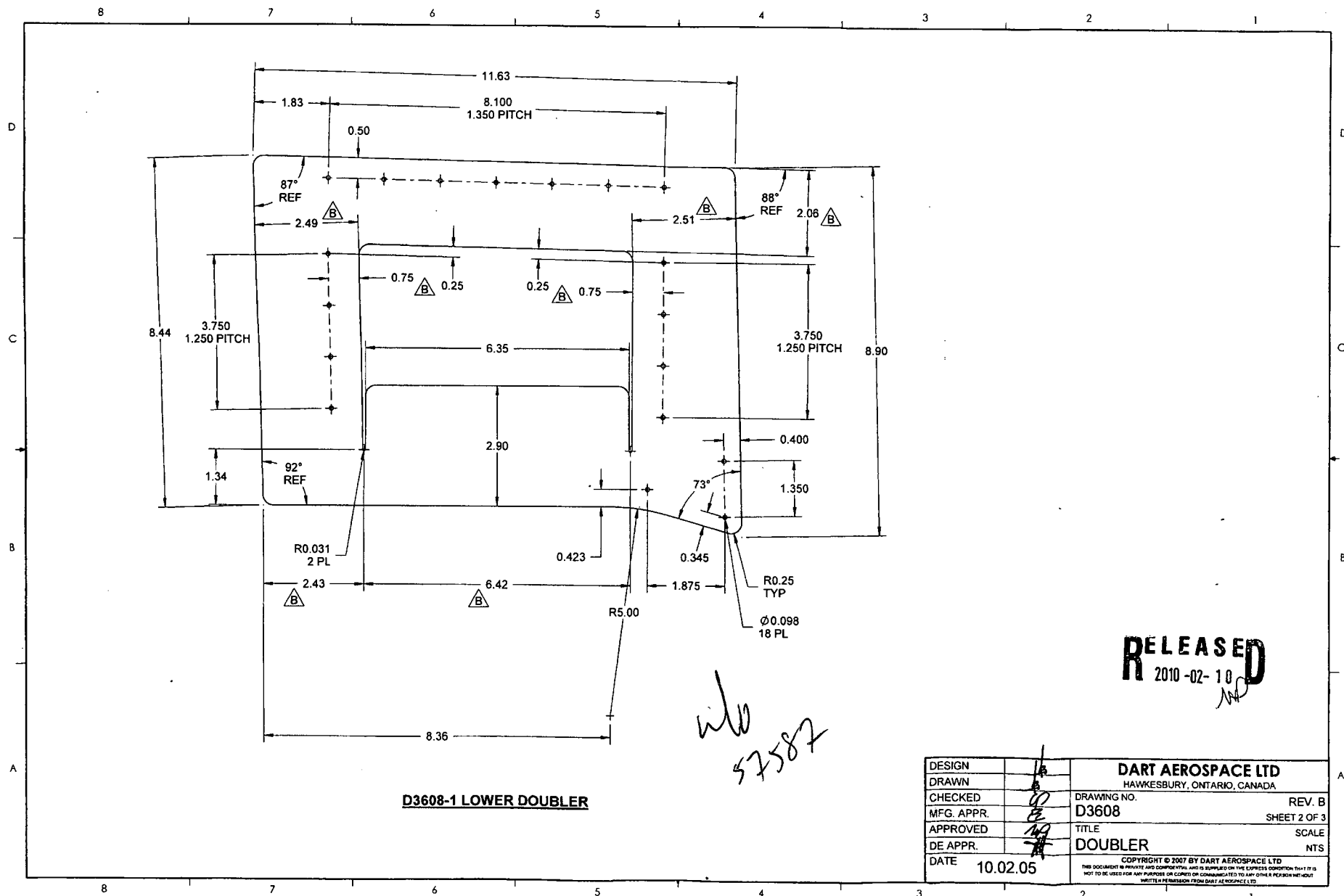
NOTES:

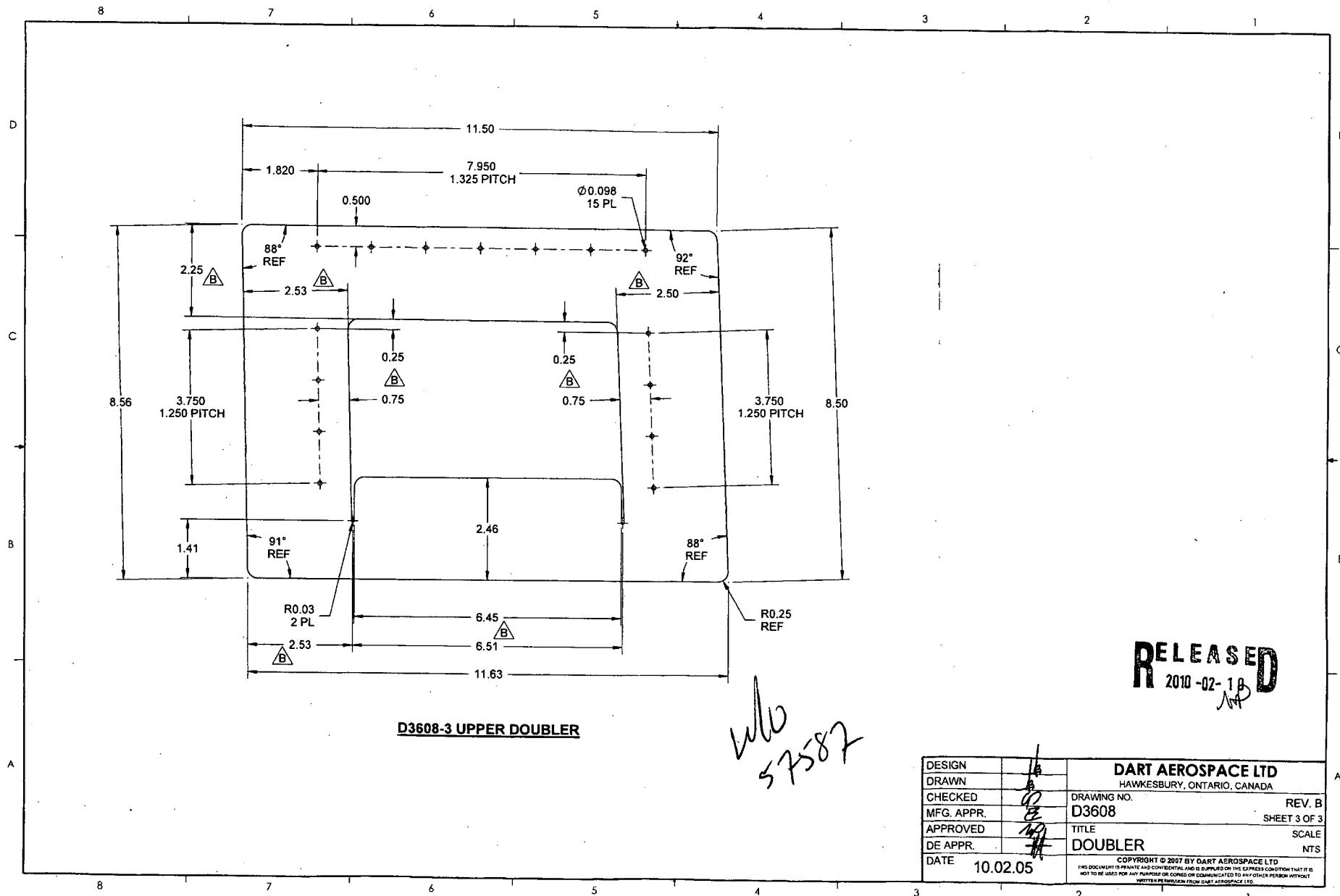
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK
PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3608-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.80 lbs EACH

B	OFFSET TOP AND VERTICAL EDGES OF RECTANGULAR OPENING BY 0.250 INWARD; ELIMINATED D3608-1F/3F; DELETED BENDING DETAILS. REASON: D3608-1A-3 NOW SOLD TO CUSTOMERS UNBENT PER PAR#09-097.	MB	10.02.05
A	NEW ISSUE	MB	07.04.11
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.02.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3608	REV. B
TITLE DOUBLER	SHEET 1 OF 3
	SCALE NTS

COPYRIGHT © 2007 BY DART AEROSPACE LTD
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.





DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. B
MFG. APPR.			D3608	SHEET 3 OF 3
APPROVED			TITLE	SCALE
DE APPR.			DOUBLER	NTS
DATE	10.02.05	COPYRIGHT © 2007 BY DART AEROSPACE LTD		
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.				